

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025667**Date Inspected:** 23-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

**CB18**

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding on OBG Cross Beam CB18 assembly. ZPMC QC CWI Li Yang was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 3 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. The welders were welding CJP replacement welds, stiffeners to deck plate hold back fillet welds identified as CB3002A-018-037, 038, 010, 012, 033, 034, 007, 008, 039, 040 as per Notification for Engineer's Review and Approval B-JC153R0, approved by ET (Eric Tsang?) on 7/9/11. This QA inspector verified this information for the following location;

Weld- CB3002A-18-

WPS- B-P-2234-TC-U4b-1

Welder- #054467, 220068, 069769

4G/SMAW/CJP

The following digital picture illustrates welding in progress on CB18.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

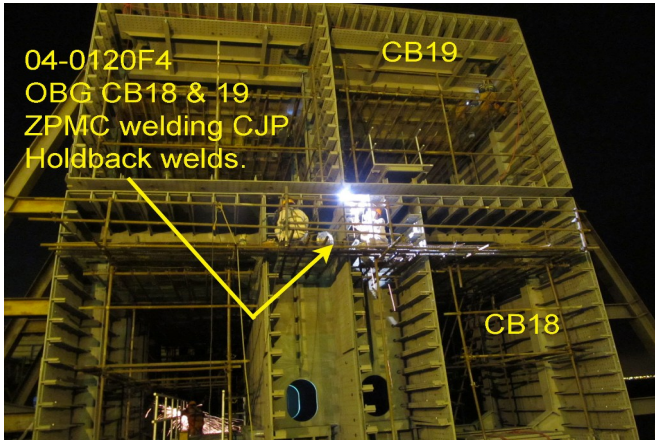
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# WELDING INSPECTION REPORT

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documents.



## Summary of Conversations:

“As noted within the contents of this report.”

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler, Mike
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Riley, Ken
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QA Reviewer
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